



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1404
Job Sheet 181344



Part No: 647.1404

Job Qty: 4 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 647.1404 REV D IPP REV:A 16.03.28 NEW ISSUE DD VERF:JLM

Ship Via:

635

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Stores/Pkg-2	9-89	NOV 07 2018
110	Packaging	4 pcs	9/10/18	9/10/18	0.00	0.00	Packaging1	9-89	NOV 07 2018
120	Small Fab	4 pcs	9/10/18	9/10/18	0.00	1.67	Small Fab	9-89	NOV 15 2018
130	QC	4 pcs	9/10/18	9/10/18	0.00	0.00	QC5	9-89	NOV 22 2018
140	Packaging	4 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1	9-89	NOV 22 2018
150	QC21-SA	4 Ea	9/10/18	9/10/18	0.00	0.00	QC21	9-89	NOV 22 2018

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.
Descriptions: 140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.9703	Cutter Sub Assembly	4 Ea (1 ea)	90-Start up Operation	S100376 S098002
647.1513	Upper Deflector	4 Ea (1 ea)	90-Start up Operation	S118028
MS21042L08	Nut	12 Ea (3 ea)	90-Start up Operation	S100409
MS27039-08-19	Screw	12 Ea (3 ea)	90-Start up Operation	S044235
NAS1149FN832P	Washer	24 Ea (6 ea)	90-Start up Operation	S100408

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.9703	4	0	0
	647.1513	4	2	0
	MS21042L08	12	1,478	0
	MS27039-08-19	12	760	0
	NAS1149FN832P	24	1,062	0

Part Specifications

Specifications could not be found.

Plex 7/26/18 7:06 AM Dart.lajeunesse.marie

647.1404

S125377

REV. D

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Work Order Deviation				Disposition				Completed By																	
Dart Aerospace Ltd. 1270 Aberdeen Street Hewesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S125377 Part: 647.1404 Job No: 181344 Serial No/Batch: S125377 Revision: D Inspector: Exp Date: Instructions: Date: 11/07/18								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY																					
Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																			
OTHER :																									